

# Work Order ID 56869

March 11, 2010 11:36:19 AM



Item ID: D3695-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Stopper

Start Date: 11/03/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 30/03/2010 Req'd Qty: 4.00

Customer:

Reference:

*10-03-11*

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3695

Rev C

100



Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blank 4.25 " long

0.00

0.00

*M.A 10/03/14*

*4 0*

110



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1- Mill as per Folio FA733 Rev: *A* & Dwg D3695 Rev: *C* 1:2-Deburr  
per dwg D3695 1:3-TAP FOR 3/8"-24 HELICOIL

0.00

0.00

*M.A 10/03/14*

*4 0*

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

*M.A 10/03/14*

*4 0*

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Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

MMA  
10/03/15

4 0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

PK 10-3-15

4 0

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

\*\*\*\*\*MASK ALL HOLES AS PER DWG

D3695\*\*\*\*\* START TIME:

9:15pm OVEN TEMPERATURE: 9:45pm FINISH

TIME: 320°

=) W 10/03/15

4 0

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Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00

BK

10-3-16

④

④



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 255

0.00



Packaging

Memo

0.00

Packaging

10-3-18 SL

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/24 JF  
MF  
10-3-18

# Picklist Print

March 11, 2010 11:36:19 AM

Page 1

Work Order ID: 56869

Parent Item: D3695-3

Parent Item Name: Stopper

Comments: IPP Rev:A 08-03-27 new issue DD verified by:JLM

Start Date: 11/03/2010

Required Date: 30/03/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B2.500X03.50 0		Purchased	No				f	33.0343	1.4807			



6061-T6 Bar 2.50 x 3.50



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	33.03425	
102838	13.1	
110936	1.03	
111700	1.365	
✓ 113403	17.53925	

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

1.4166 FT M.A

10/03/14

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<i>56869</i>
<b>Description:</b> Slider		<b>Part Number:</b>	D3695-3
<b>Inspection Dwg:</b> D3695 <b>Rev:</b> C		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
         
 ☐ **Prototype**

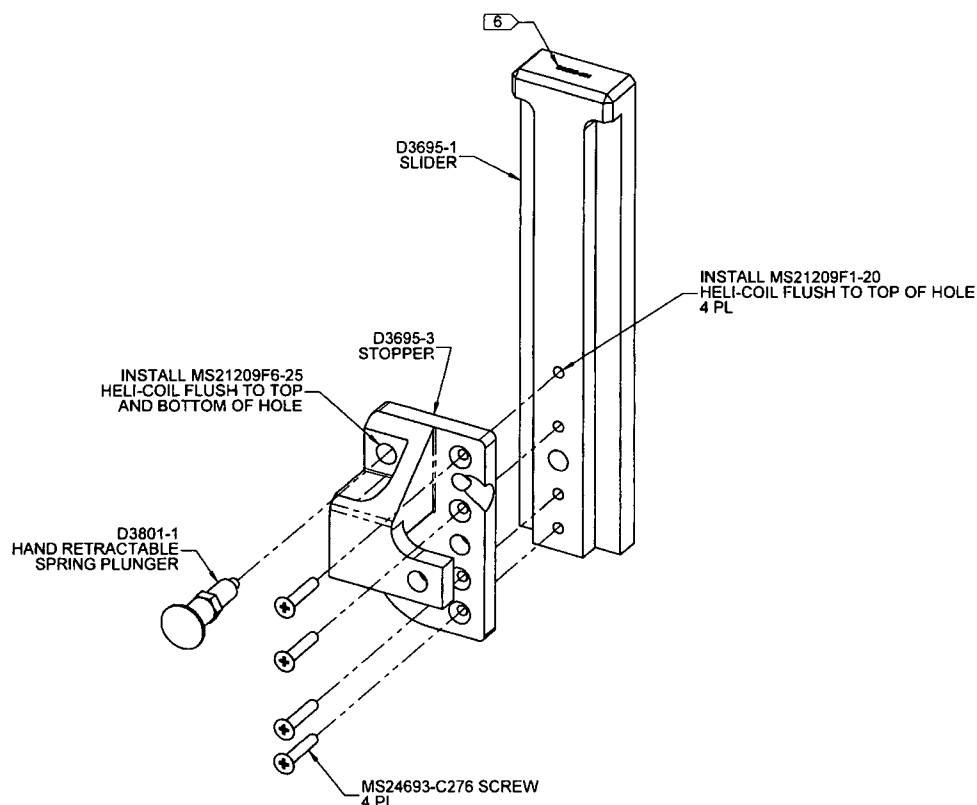
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.625	+/-0.010	0.623	✓			
1.063	+/-0.010	1.063	✓			
Ø0.391	+0.006/-0.001	Ø0.393	✓			
Ø0.194	+0.005/-0.001	Ø0.196	✓			
Ø0.425 x 100°	+/-0.010 x 0.5°	Ø0.423 x 100°	✓			
Ø0.386	+0.006/-0.001	Ø0.388	✓			
0.450	+/-0.010	0.450	✓			
2.025	+/-0.010	2.026	✓			
0.83	+/-0.010	0.830	✓			
0.575	+/-0.010	0.575	✓			
0.500	+/-0.010	0.500	✓			
Ø0.328	+0.006/-0.001	Ø0.330	✓			
0.500	+/-0.010	0.502	✓			
1.813	+/-0.010	1.815	✓			
2.62	+/-0.030	2.622	✓			
1.075	+0.010/-0.000	1.079	✓			
0.38	+/-0.030	0.375	✓			
2.313	+/-0.010	2.318	✓			
4.00	+/-0.030	4.000	✓			
1.83	+/-0.030	1.831	✓			
1.23	+/-0.030	1.222	✓			
2.25	+/-0.030	2.250	✓			
0.650	+/-0.010	0.651	✓			
0.279	+/-0.010	0.277	✓			

<b>Measured by:</b>	<i>H.A</i>	<b>Audited by:</b>	<i>MWA</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	<i>10/03/14</i>	<b>Date:</b>	<i>10/03/15</i>	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.11	New Issue	KJ <i>[Signature]</i>	<i>[Signature]</i>

8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
1	X	D3695-041	SLIDER ASSEMBLY
11	1	D3695-1	SLIDER
12	1	D3695-3	STOPPER
15	1	D3801-1	HAND RETRACTABLE SPRING PLUNGER
21	4	MS21209F1-20	HELI-COIL, SCREW LOCKING (RED)
22	1	MS21209F6-25	HELI-COIL, SCREW LOCKING (RED)
23	4	MS24693-C276	SCREW



**D3695-041 SLIDER ASSEMBLY**

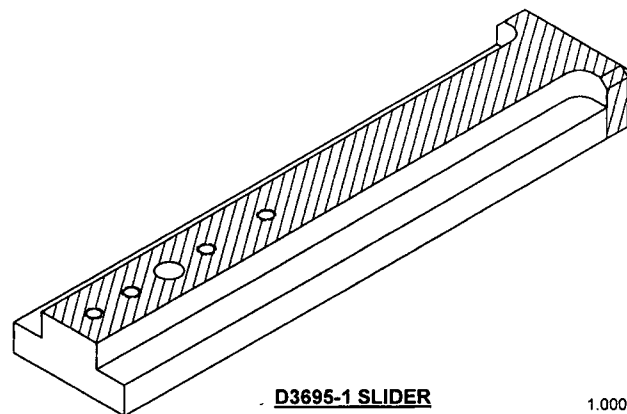
**D3695-041 NOTES:**

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3695-041" USING FINE POINT PERMANENT INK MARKER LOCATED APPROXIMATELY AS SHOWN
- 7) WEIGHT: D3695-041 = 0.64 lbs

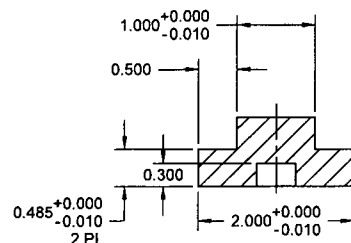
**RELEASED**  
9/10/05 NTP

C	UPDATED BOM TO CURRENT STANDARDS; REVISED ITEM 12 (ZN D3-1); DIMS 1.83 AND 1.075 <sup>±.005</sup> WERE 1.81 AND 1.063 <sup>±.005</sup> (ZN B6-3 AND C4-3). REASON: COMPENSATE FOR PAINT THICKNESS AND ELIMINATE RATTLE UPON ASSEMBLY.	MB	08.11.04
B	P/N D3808-1 WAS WIP-510 (ZN C7-1 AND D3-1) - REASON: PURCHASED PARTS NOW PROCURED THROUGH D3801 SPEC CONTROL DRAWING	MB	08.06.26
A	NEW ISSUE	MB	08.03.14
REV.	DESCRIPTION	BY	DATE
DESIGN	LA		
DRAWN	LA		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	08.11.04		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3695</b> REV. C <b>SLIDER ASSEMBLY</b> SCALE NTS <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

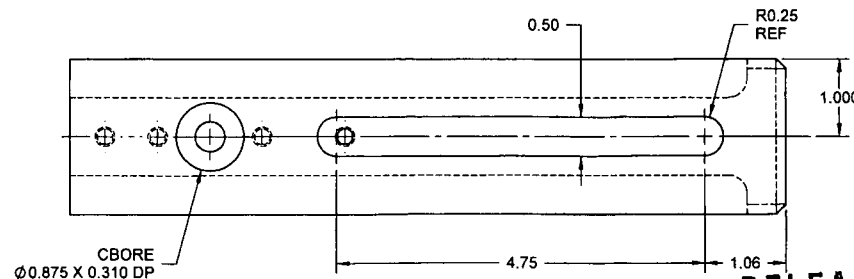
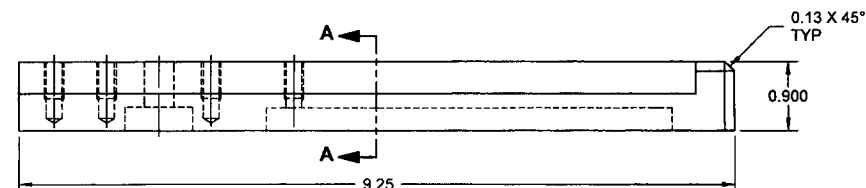
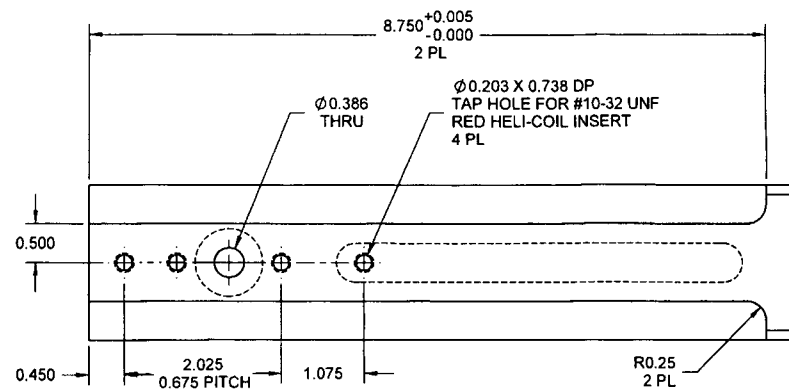
8 7 6 5 4 3 2 1



**D3695-1 SLIDER**



**SECTION A-A**



**D3695-1 NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART  
QSI 005 4.3 - MASK ALL HOLES AND UNHATCHED AREAS
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.43lbs

*w/o 50869*

**RELEASED**  
*09/02/05 NW*

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D3695</b>	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>SLIDER ASSEMBLY</b>	NTS
DATE	<b>08.11.04</b>	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

